



## Contract attached pages

NO.	Description	QTY
1	1.SJZ80/156-YF1250 Wood Plastic Door Panel Production Line	1set
1.1	SJZ80/156 Twin screw extruder	1set
1.2	YFD1250 Vacuum calibration table	1set
1.3	YFY1250 Hauling-off machine	1set
1.4	YFY1250 Cutting machine	1set
1.5	YFF1250 Stacker	1set
2	Mould	
2.1	800 partition plate mould	1set
3	High pressure lamination machine	1set
4	SRL500/1000high speed hot and cold mixer with otc-1000 automatic screw feeding machine	1set
5	Milling machine	1set
6	SWP800 Crusher	1set
7	SMF800 Pvc Pulverizer	1set
8	hinge	5000pcs
9	bottom support	5000pcs



# SJZ80/156-YF1250 Wood Plastic Door Panel Production Line

## 1. Power condition

- 1.1 Standard: 380V, 3-phase, 50Hz ( Or according to customer's request)
- 1.2 Working voltage: 380V
- 1.3 Control cabinet: 220V
- 1.4 Protective measure: ground connection

## 2. Compressed air

- 2.1 Valid working pressure range: 0.4-0.6Mpa
- 2.2 Utility condition: no dust, no smoke, no oil stain

## 3. Cooling water

- 3.1 Valid working pressure range: 0.2-0.4Mpa
- 3.2 Water temperature: 10-15°C



## II Technical parameters

### 1.1 SJSZ80/156 twin screw extruder

Items	Technical Parameters
<b>1. Extruder</b>	
Outer Size (mm)	4750mmX1550mmX2460mm
Total Weight (Kg)	5000Kg
Hopper Taper	60°
Inlet wire terminal of power resource	Three-phase four-wire system
Manufacture of the motors, pumps	The main AC motor: 0.75KW; Motor for feeder: 0.75KW ABB
Type of Temperature control curve	Temperature fluctuating self-adjusting (PID Type)
Computer control system	Omron control meter
The brands and origin places of the conductive oil; The temperature of carbon deposit	YD132, <b>Jiangyin Chemical Plant</b> ; Carbon deposit temperature 200°C.
Pressure Display	With melt pressure display
Type of the feeder	Spiral spring feeder+ forced feeder
Connection of die head with flange	By bolts





The display method of data in operating panel	Mainly digital display
The advantages over other companies in this field	Good shearing, high output, reasonable design, high accuracy and easy control. High-grade materials and parts with steadfast performance.
<b>2. Screw</b>	
Diameter (mm)	80/156mm
Effective length (mm)	1815mm
Quantity	2 pieces
Mesh type	Conical mesh
Total torque (KNm)	14.2KNm
The rotation speed (r/min)	1~36.9 (Counter-rotating)
Thickness of nitrided layer	0.6~0.7 mm
Suitable for powder material or not	Yes
Heating method of the screw core	screw core constant temperature unit: SZK-3
<b>3. Barrel</b>	
Barrel type	Integer
Heating method	Air cooling unit, special stainless cover and Aluminium heating rings are used on the barrel
Heating zones	5 zones (include of interflow channel )
Heating power (kW)	36Kw
Temperature range (°C)	50~300°C
Cooling zones	5 zones, 750w motor, volume 1200m <sup>3</sup> /min
Adapter	Stainless steel 3Cr13, chromium plated, with inner convergent flow type3Cr13
Manufacture of the barrel and screw	
Thickness of nitrided layer(mm)	0.6~0.7mm
<b>4. Driving system and speed reducing system</b>	
The power of main driving motor (K w)	75Kw



Working method of the main motor	Three-phase asynchronous motor, connected to the gearbox by coupler
The rotation speed of the main motor(r/min)	30~1500r/min
The type of gearbox	Helical gears, hardened
Gears	Carburized and ground; The material is 20CrMoTi
Distribution box	The two distribution axles are driven by super-taper spiral gear
Speed-adjusting method of the main motor	Governed by AC transducer exported from ABB
<b>5. Vacuum exhausting system</b>	
Type	Monoblock and hydroseal vacuum pump
Motor power (kW)	4Kw
Working method of the motor	Three-phase asynchronous motor
Vacuum degree (M Pa)	0~-0.075Mpa
Quantity of vacuum pumps	One set
<b>6. Calibrated feeding system</b>	
Feeding method	Calibrated feeding
Feeding screw's rotation speed (r/min)	0.5~30r/min
Motor power (kW)	0.55KW
Motor rotation speed	10~1500r/min
Speed-adjusting method	Governed by AC transducer
Working method of the motor	3-phase asynchronous motor, direct connection to reducer
<b>7. Constant temperature oil tank system</b>	
Motor power (KW)	0.75 Kw
The working method	AC asynchronous motor
Oil temperature control range (°C)	50~200°C
Heating power (kW)	6 Kw
Working method of the pump	Direct connection to the motor
Currency (L/min)	10 L/min
Working pressure (MPa)	0.2~0.3 MPa
Heat exchange medium	Water (the heat exchanger should be cleaned annually)



## 1.2. YFD 1250 YFD1250 vacuum calibration table

### 2.1 Material is stainless steel

2.2 Length: 6000mm

2.3 Width: 1250mm

2.4 Center distance of aluminum lead rail: 1200mm

2.5 Vacuum pump: 11kw\*2 sets, 5.5kw\*2 sets, 4 sets of direct-connecting water-ring vacuum pump, with erasure device and integral base board; precise installation, anti-shake, with over-current protection (should discharge water in winter avoiding frost damage)

2.6 Vacuum degree: 0 -0.09 Mpa

2.7 Water power and quantity: 5.5kw, 1.5kw; direct-connecting water pump 1 set

2.8 Vacuum nozzle quantity: 48pcs (yellow color)

2.9 Water nozzle quantity: 44 pcs (blue color)

2.10 Material and section type: stainless steel trough, mould connecting rail is made by cast-aluminum profile, surface hard material is anodic oxidation or silver paint, rack and water pipe is as w whole using stainless steel square pipe, wearing-resistance and anti-corrosion.

2.11 Air and water nozzles position and way: air nozzle ball valve is at the upper

of machine body, water nozzle is at upper of trough square pipe rack.

2.12 Electrical control cabinet and operation screen have water-proof protection.

2.13 Whirling blower: 3kw, used for dry product surface water.

2.14 Back and forth moving: screw connects the sizing table and hauling machine, screw gear motor, motor-driven moving.

2.15 Other regulation: trough flat inclination and sizing table position and lifting

are all manual regulation.

2.16 Vacuum water meter displays the vacuum degree and water temperature of each zone.

2.17 Electrical part: contactor SIEMENS; air switch: CHNT

2.18 Cooling water consumption: 16m<sup>3</sup>/h





### 1.3. YFY1250 hauling-off machine

- 3.1 Hauling-off belt quantity: 2 pcs
- 3.2 Each hauling-off belt has gear motor, gear motor: 5.5kw/set. Controlled by frequency inverter.
- 3.3 Frequency inverter by ABB
- 3.4 Hauling belt length: 3000mm
- 3.5 Hauling rubber block specification: 300X45X35, inside lining steel board Q235 connect with base board, rubber block uses Korea supplier, wearing-resistance, trapezoidal section, touching surface with groove. 4 parallel pedrails haul evenly.
- 3.6 Valid length of hauling belt: 300mm\*3
- 3.7 Rubber block and pedrial connecting mode: axial pull, reliable fixation
- 3.8 Hauling speed: 0.5-5m/min
- 3.9 Pneumatic parts working pressure: 0.5-0.7Mpa
- 3.10 Hauling belt height can be adjust by air valve on control panel, used for fine adjustment while running.
- 3.11 Hauling rack center height: 1100mm, adjustable

### 1.4. YFQ 1250 Cutting machine

- 4.1 Power of cutting motor: 2.2kw
  - 4.2 MAX cutting height: 1000mm
  - 4.3 Power of dust suction blower: 2.2kw
  - 4.4 Cutting procedure control is by Mitsubishi PLC
  - 4.5 Cutting blade: high-quality alloy steel, suitable for PVC profile cutting, blade outer diameter 300mm
  - 4.6 Rubber block pressing device provides precise cutting precision, pneumatic parts: SHANGHAI
  - 4.7 Cutting table moving and blade rising are control by cylinder and PLC.
  - 4.8 Working pressure: 0/5-0.7Mpa
  - 4.9 You can choose manual cut or auto cut modes.
  - 4.10 Limit switch for length metering
  - 4.11 Hauling and cutting electrical part: Mitsubishi PLC, SIEMENS contactor, JIUCHUAN control transformer, CHNT air switch
- Note: hauling machine and cutting machine are separate.

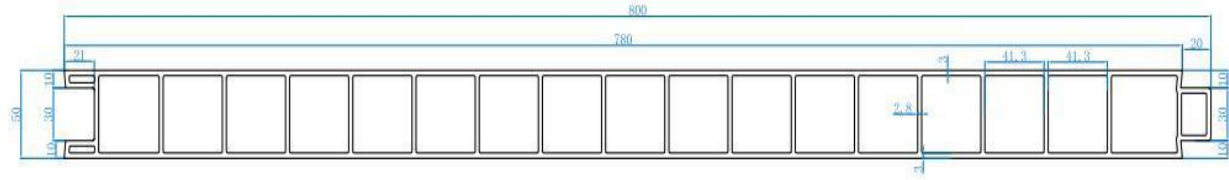
### 1.5. YFF 1250 Stacker

- 5.1 Length: 6m
- 5.2 Suitable for product width: 1000mm
- 5.2 Cylinder over turn, limit switch for length metering
- 5.3 Over-turning rack mode: can distach; product touching part is coated by rubber block.
- 5.4 With one manual material wagon

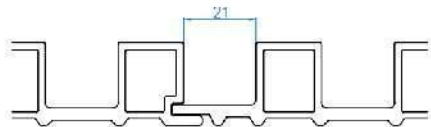
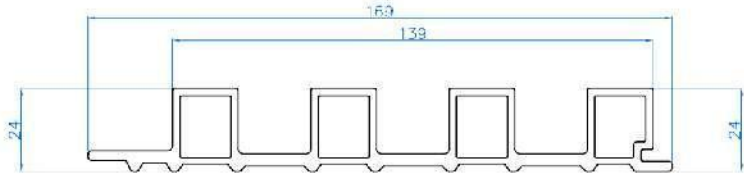


2. mould 4 sets as below

1. Partition board mold drawing



2. Grating mould

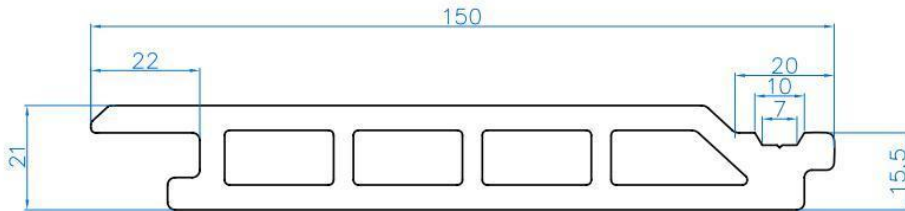


未注壁厚: 2.1mm

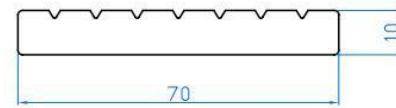
Without note the wall thick is 2.1 mm

grating

3. wall panel mould



4. 70mmx10mm sauna board mold



For 2, 3, 4 is made by 65/132 extruder, the Partition board mold is made by 80/156 extruder



**H.SAT 3.High pressure lamination machine**

Style HSTPUR-800  
 machine dimension: L5022xW1300xH2700(mm)  
 width of laminaiton 0-820mm  
 height of laomination 80mm  
 speed 0-30m/min  
 transmission power 2.2Kw  
 total power about18Kw

**HSTPUR-800 lamination equipment**



**4.SRL500/1000high speed hot and cold mixer with otc-1000 automatic screw feeding machine**

<b>1.1 Heating mixer</b>	
Motor power	47/67kw
Cover of boiler	one set made of alloy
Body of boiler	one set made of stainless steel
Electric heating	9kw
Lodicules & guiding board	one set
Air tank	one set
Air moving system	one set
<b>1.2 Cooling mixer</b>	
Total motor power	15kw
Body of boiler	one set made of stainless steel
Lodicules of water circling cooling	one set made of stainless steel
Running Water pressure	≥0.1Mpa
Electric equipment controlling set	one set
Controlling platform	one unit welded by steel
External dimension	4425 × 2480 × 3300mm
Weight	5400 kg





## 5.Milling machine

No.	Description	Instruction	No.	Description	Instruction
1	machine style	921style	11	Control system	Shanghai Weihong control system
2	Machine travel	900×2100 (MM)	12	Spindle power	4kw 380V air-cooled spindle
3	feeding height	200MM	13	Tool diameter	3.175-4-6-12.7
4	body of machine configuration	Full welding of steel frame	14	Spindle speed	6000-18000r/min
5	positioning accuracy	±0.15/300mm	15	Empty speed	10000mm/min adjustable
6	Guide rail configuration	Square track	16	Processing speed	0-5000mm/min adjustable
7	Rack configuration	High precision helical gear	17	Machine belt	Data line, power line, control card, water pump
8	Lead screw configuration	Z ball screw	18	Machine table	Aluminum alloy table
9	Motor configuration	Stepper motor 450b	19	Pneumatic pressure wheel	a set
10	Drive configuration	Stepper motor driver 860h	20	Power Distribution Box	Independent special distribution box
					One computer





### 6.SWP800 Crusher

No	Part	Qty	Parameter
1	main motor	1pc	37kw
2	moving blade	25pcs	
3	static blade	2pcs	
4	electric cabinet	1pc	15000kgs
5	vibrating hole		φ16, output 500-800kg/h

### 7.SMF800 Pvc Pulverizer

7.1 motor power: 75kw ;

7.2 air inlet motor power:11kw;

7.3 air outlet motor power:0.75kw

7.4 vibrating screen:φ1200mm, motor power:1.5kw

7.5 Output:20-100 mesh 400-800kg/h

7.6 weight:1500kg

No	Part	Qty
1	main motor	1pc
2	vibrating feeder	1pc
3	air inlet motor	1pc
4	air outlet motor	1pc
5	dust collector &duct	1set
6	control cabinet	1pc
7	pocket dust collector	1pc
8	vibrating screen	1pc